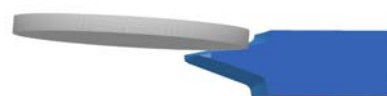
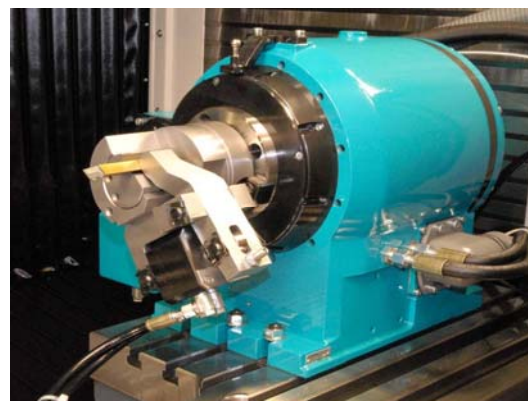











## Gear Blade Pentac 6"

A12-310

The profiled Gear Blades are ground with DXF based Profileoperation being clamped horizontally in a specially designed automatic clamping device. The 1A1-wheel is used on both sides to grind either the pressure side of the blade or the clearance side of the blade.



### 1. Cycletime for Production

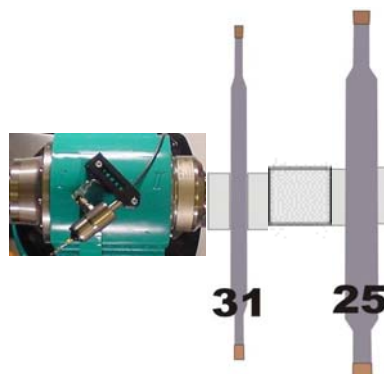
| Tool specifications<br>inner blade and outer blade 6"<br>Material HSS |  |   |   |   |   |
|---|--|---|---|---|---|
| Operations  |  |    |    |    |    |
| Feed [mm/Min]   | 2000   | 40  | 40  | 80  | 80  |
| Power [kW]  |  | 1   | 1   | 1   | 1   |
| Cutting feed [m/s]  |  | 32  | 32  | 32  | 32  |
| Used wheels   |  |  |  |  |  |
| Grinding time [s]   | 18   | 109   | 109   | 22  | 22  |
| Total cycle time  | 4 Min 41   |   |   |   |   |

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

25 Ø250 1A1 B126

31 Ø250 14A1 B126



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : CORVUS GDS, GEMINI DMR  
Control: Fanuc 31i  
Coolant: Synthetic Oil, pressure 6 - 7 bar  
Software: Quinto 5

responsible engineer: OP, 23.4.09

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